

Date: Monday, 09/03/2009 1:42:02 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT CAP
Job Number : 46327	
Estimate Number : 10312	
P.O. Number :	Part Number : D2646
This Issue : 09/03/2009 S.O. No. :	Drawing Number : D2646 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 43801	Material :
Written By :	Due Date : 23/03/2009 Qty: 50 Um: Each
Checked & Approved By : <u>JUD 09.03.09</u>	
Comment : Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM	
Est Rev:H Changed Inserts 07-02-19 JLM	
est rev I changed inserts 07.06.11 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 8363

C 209103110

1-Spin as per Dwg D2646

2-Material release note required

(50)

2.0	D2646P	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

C 209103110

counters

(50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

C 209103110
 809103110
 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:42:02 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 46327

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Open holes to .297 as per Dwg D2646.

3-Deburr

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:35
320°
9:05

UMD/Fx

09/03/30

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

INSERT

Batch: M108606

94

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

94

09-03-31

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S02/03/31 (X50) counters

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT CAP

Job Number: 46327

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-6

JS

09-03-31 (x50)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/01 JS

Job Completion



MF
09-03-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

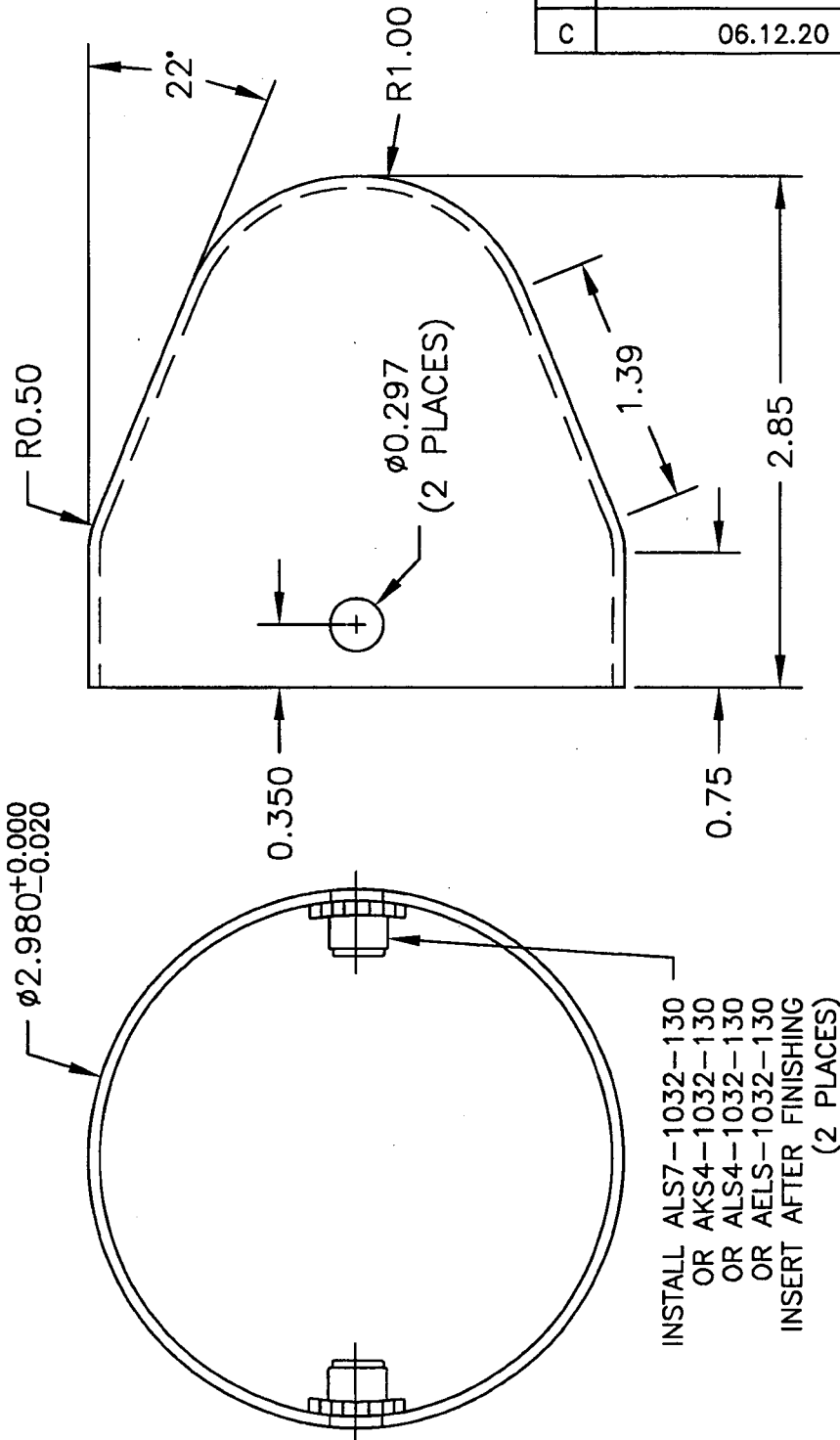
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS		DRAWN BY PH		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. REV. C D2646 SHEET 1 OF 1	
DATE 06.12.20		TITLE AFT CAP		SCALE 1:1	
A	97.03.25		NEW ISSUE		
B	05.04.01		CHANGE TO CLOSED INSERTS		
C	06.12.20		CHANGE TO OPEN ENDED INSERTS		



RELEASED

07.02.12 *[Signature]*

ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2646 AFT CAP

- 1) MATERIAL:
2) FINISH:

3) SHOP COPY
4) RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40327

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Sieg's Manufacturing Ltd.
Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • Fax: (604) 530-7490

Packing Slip

Packing Slip No.:

36519

Date:

03/19/2009

Page:

1

Sold to:		Ship to:	
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	
Order No.:	P8363	Sold By:	KAULBARS, KALE
Shipped By:	FEDEX	Ship Date:	03/20/2009
Tracking No.:			

Item No.	Unit	Description	Quantity
D2646P	EACH	AFT CAP	50
<div>S 9/3/23</div>			
Comment:			



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: March 20/09
Customer: Dart Aerospace
Packing Slip: 36519

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By.
D2646P	50	1461	N/A	✓	HK

Notes:

S
2/3/23

Material Certification Attached: YES.

Verified by ThyssenKrupp Materials NA, Anna Riggs
Quantity: 3154 LB
Cust PO#: 717
Customer: SIEGS MANUFACTURING LTD. ***

(1 of 1)
2008-04-21
Shipper#: U47541
Cust Part#:

PRECISION COIL, INC.

7/10/2007

Post Office Box 2650
U.S. 50 West
Clarksburg, WV 26302
(304) 622-1984
(304) 622-2301

CS 1775

CERTIFIED INSPECTION REPORT

Report No. 31657

Test Date 7/10/2007

Lot # / Heat # / S/O # 76086

Customer Name COPPER & BRASS SALES

Alloy 1100

Customer PO # CS1775

Temper O

Test Specification AMSQQA250/1A &
ASTMB209-06

Gauge (in) .063

Width (in) 48

Length (in) 144.000

Net Weight (lbs) 10,522#'S

S
91363

Test No Spec ID YLD (psi) UTS (psi) ELONG in 2" (%)
38480 1100-O 5,714 13,038 33.00

608218

ALLOY	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHER		Al
									EACH	TOTAL	
1100	Si+Fe	≤.95	.05-.20	.05	---	---	.10	---	.05	.15	99.00 Min
ACTUALS											
	.12	.60	.10	----	----	----	.01	----	.05	.15	REMAINDER

THIS REPORT INDICATES THE CHEMICAL ANALYSIS RANGE TO WHICH THE ITEMS LISTED WERE MANUFACTURED
BASED ON CERTIFICATE OF COMPLIANCE FURNISHED TO US BY THE PRODUCER. WE CERTIFY THEM TO BE
WITHIN THE LIMITS SHOWN. FOR ALLOY 1350 ONLY A MINIMUM ELECTRICAL CONDUCTIVITY OF 62% I.A.C.S.
AT 20 DEGREES CELSIUS IS GUARANTEED.

By: UNR umf Date: 7/13/07